

Work Order ID 59691

Wednesday, June 09, 2010 1:42:50 PM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Item Name: GHW Lug

Stop



Start Date: 6/9/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10/06/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

amk 10/06/11

30

Ø

Jeaspa Bandsaw

Cut blank: 2.750" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

LF 10/06/17

30

Ø

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 □ Dwg Rev: *AA* Folio Rev:

□ 2-Deburr

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

LF 10/06/17

30

Ø

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Stop

Item Name: GHW Lug

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DIT 10/06/08

30 0

140

Identify as per dwg & Stock Location: EL

0.00



Packaging

Memo

0.00

Packaging

10-6-18 300

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21 ME 10-6-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, June 09, 2010 1:42:55 PM

Page 1

Work Order ID: 59691

Parent Item: D3404-1

Parent Item Name: GHW Lug

Comments: IPP Rev: A ☐ 05.09.01 ☐ New issue ☐ KJ/JLM ☐
IPP rev B 09.01.28 new geometry rev.C

EC verified by: DD

Start Date: 6/9/2010

Required Date: 6/17/2010

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Otv	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	15.5597	0.2291	7.234737			



304 BAR .750 X 2.50



Location

MAT53

112663

112697

Loc Qty

15.5597

1.4597

14.1

Loc Code

X 7 parts
X 23 parts

1.4597 ~~1.4597~~

5.775 ~~5.775~~

Conf 10/06/11

Dart Aerospace Ltd

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Dart Aerospace Ltd

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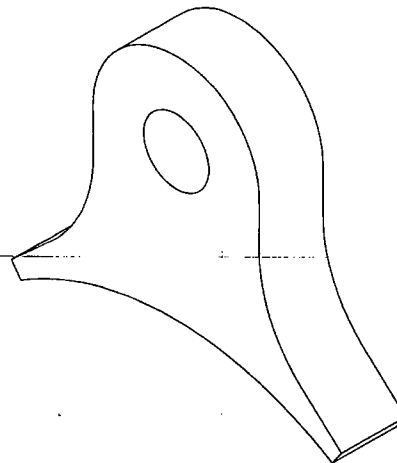
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 59691
RD 10-6-09



D3404-1 GHW LUG

RELEASED
08/12/09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
 PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
 REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3404	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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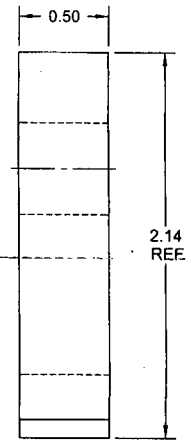
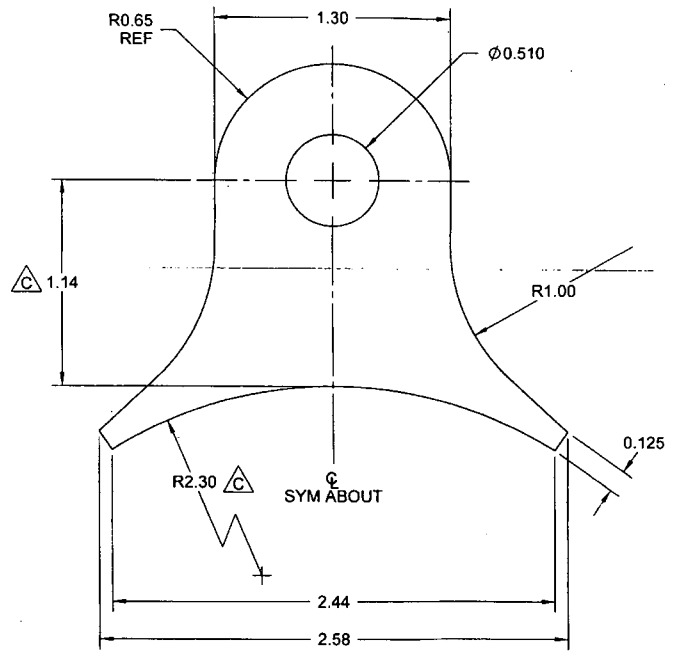
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NOTE: Date & initial all entries

ULO 5909

9/10
11/14/0
-260
-880



RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
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